

Title (en)

WELDING GROOVE JOINING METHOD, DOUBLE-WIRE WELDING METHOD AND SYSTEM THEREOF

Title (de)

VERFAHREN ZUR VERBINDUNG VON SCHWEISSNÄHTEN, DOPPELDRAHTSCHWEISSVERFAHREN UND SYSTEM DAFÜR

Title (fr)

PROCÉDÉ DE LIAISON DE RAINURE DE SOUDAGE, PROCÉDÉ DE SOUDAGE À DEUX FILS ET SYSTÈME ASSOCIÉ

Publication

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Application

EP 10840217 A 20100630

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Abstract (en)

The invention provides an overlapping method of welding groove, a twin wire welding method and a system thereof. The twin wire welding method comprises the steps of: setting a tracking angle range of a tracking sensor according to a groove angle, wherein the tracking angle range comprises the groove angle which is an angle of a welding groove by overlapping an upper profile and a lower profile; setting a welding angle of a welding torch according to the groove angle, wherein the welding torch comprises a first welding wire and a second welding wire, the first welding wire is connected to voltage used for root penetrating, and the second welding wire is connected to voltage used for surface filling; controlling the welding torch not to open an arc, and verifying whether the welding angle is correct along the welding groove under the guidance of the tracking sensor; controlling the welding torch to open the arc and welding along the welding track of the welding groove according to the verified welding angle if so. The technical scheme of the invention overcomes the technical defects of inconvenient welding by the welding torch caused by the fact that the welding angle of the welding groove is appropriately a right angle or an acute angle in the prior art.

IPC 8 full level

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